

Date: Tuesday, 14/04/2009 11:28:21 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 212/205 HIGH FED X-TUBE ASSEMBLY
<b>Job Number</b> : 47147	
<b>Estimate Number</b> : 10254	
<b>P.O. Number</b> :	<b>Part Number</b> : D212664101
<b>This Issue</b> : 14/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D212-664-141 REV C
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : CROSSTUBES	<b>Drawing Revision</b> : C
<b>Previous Run</b> : 46729	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 24/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	
<b>Comment</b> : Est Rev:E 04-02-16 Reformat KJ/DS	
Est Rev:F 06-03-29 Remove Coments on Pick List JLM	
Est Rev:G 07-04-30 As per Rev C JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	DC	DOCUMENT CONTROL
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*for JLD 09/04/22*

**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels as per PPP D212-664-101 CHG003

*09/04/23*

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

3.0	D212664101TRN	Crosstube Turning Detail
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch *B-46869*

*MB*

*09-04-14*

*①*

4.0	BENDING	BENDING MACHINE - SKIDTUBES
-----	---------	-----------------------------

**Comment:** BENDING MACHINE

Bend tube as per Dwg D212-664-141 using CNC bender program 212-fw and Folio FT015

*MB*

*09-04-15*

*①*

5.0	QC15	DIMENSIONAL CHECK OF X-TUBES
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**Comment:** DIMENSIONAL CHECK OF X-TUBES

*09/04/15*

*B 47147 D212-664-101*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: 212/205 HIGH FED X-TUBE ASSEMBLY

Job Number: 47147

Part Number: D212664101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill pilot holes in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549

2-Ream hole to finish size in tube as per Dwg D212-664-141 using drill Jig DT8548 & DT8549. Check dimensions between holes, both sides on both cuffs, to ensure alignment with saddle holes.

3-Deburr & Inspect for surface damage. Repair damage within limits as per Dwg D212-664-141

4-Scribe part # and batch # using vibrating stylus as per Dwg D212-664-141

ET  
09-04-15

ANM 7-4-15

ET 09-04-15

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 within 24 hours of bending and drilling

ANM 7-4-15

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

809/04/15 (40)

9.0

OUTSIDE SERV.11

OUTSIDE SERVICE -CROSSTUBES



Comment: Sub-Contracting OUTSIDE SERVICES

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 8579

LPI as per ASTM 1417 Level 2

Attach copy of NDT results to work order

CL 09/04/17  
①

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Inspect for transit damage Ensure copy of NDT results attached to work order.

CL 09/04/16 (1)

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Inspect for damage & ensure results are as per Dwg D212-664-141

MM 09 04 17 (1)

# Dart Aerospace Ltd

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Job Number: 47147

Part Number: D212664101

Job Number:



Seq. #:	Machine Or Operation:	Description :
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12.0	SPRAY PAINTING	SPRAY PAINTING
------	----------------	----------------



Comment: SPRAY PAINTING

1-Prime inside and outside crosstube as per QSI 005 4.2

2-Paint outside crosstube with White Imron as per QSI 005 4.2

PRIME:

Start Time: 7:30 AM

Finish Time: 8:00 AM

PAINT:

Start Time: 10:00 AM

Finish Time: 10:45

ml 09 04 17 ①

13.0	QC14	INSPECT SPRAY PAINT
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Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

09-04-20 ②

14.0	D28931	2.75 Support
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part number Description Batch

2 D2893-1 Support 42440

ml 09 04 20

15.0	D3595063450	RUBBER CUSHION
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Comment: Qty.: 4.2000 Each(s)/Unit Total : 4.2000 Each(s)

Rubber Cushion (per sq ft)

.630" X 4.5" 4PCS

Batch: 43210

ml 09 04 20

16.0	MS2192025	Clamp(per MIL-DTL-8783C)
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Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part number Description Batch

4 MS21920-25 Clamp 109955

ml 09 04 20

W/O:		WORK ORDER CHANGES					
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Description :

17.0

CROSSTUBES

CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Lightly scuff the bonded area using a 320 grit sand paper and clean the area with 41058 wash 'n' wipe

2-Install supports with magnobond as per QSI 015 Adhere for for 12 Hrs

A/R 6398 Magnobond

Batch: 111299

Expiry Date: 02/2010

3-Install clamps as per Dwg D212-664-141. Torque clamps to 80-100 in lb.

ml  
09 04 20 ①

ml 09 04 21 ①

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/22 ①

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D34281

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

PLACARD

Batch: 42448

SS 09/04/22 ①

21.0

AN635A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109282

SS 09/04/22 ①

22.0

AN636A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M116155

SS 09/04/22 ①

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number:



Seq. #:

Machine Or Operation:

Description :

23.0

AN960JD616

Washer



Comment: Qty.: 18.0000 Each(s)/Unit Total : 18.0000 Each(s)

Washer

Batch:

M110704 x16 M111193 x2

24.0

MS21042L6

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Nut

Batch:

M110002.

25.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

26.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Identify and pack for shipping as per PPP D212-664-101

27.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



h 09.04.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

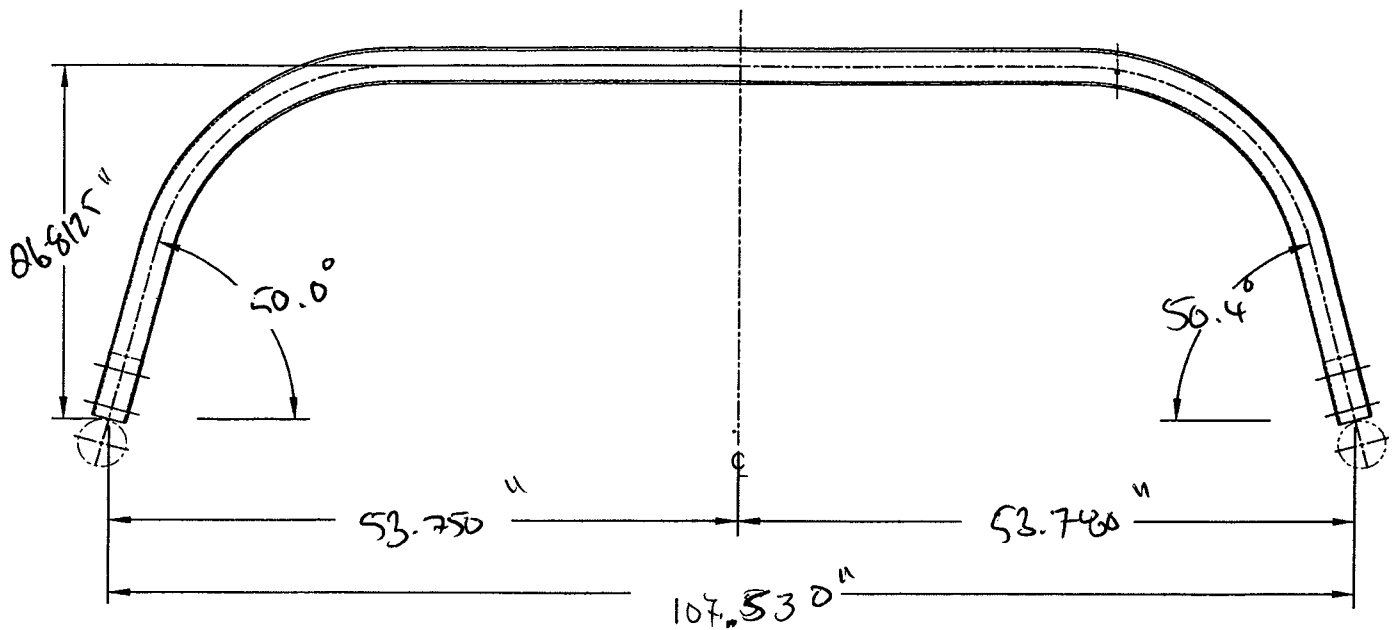
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 47147
<b>Description:</b> Crosstube High Fwd (205/212/412)		<b>Part Number:</b> D212-664-141
<b>Inspection Dwg:</b> D212-664-141 <b>Rev:</b> C		<b>Page 1 of 1</b>

Required Dimension	Min	Max
Height	26.79	27.05
1/2 Span	53.59	53.85
Angle	49	52
Total Span	107.18	107.7



Comments

QC15 Inspection	S
Date	09/04/15

Rev	Date	Change	Revised by	Approved
A	07.02.06	New Issue	KJ/JM	
B	07.05.31	Dimensions updated per Dwg Rev C	KJ/JM	



DESIGN <b>PH</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <b>GP</b>	APPROVED <b>[Signature]</b>	DRAWING NO. D212-664-141	REV. C SHEET 1 OF 3
DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD) NTS	
A	00.12.12	NEW ISSUE	
B	05.02.04	ADD HOLES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	
C	07.03.08	REMOVE -851 ABRASION STRIP; ADD MAGNOBOND 6398, CUSHION, REVERSE CLAMPS	

RELEASED

07.04.24 **[Signature]**

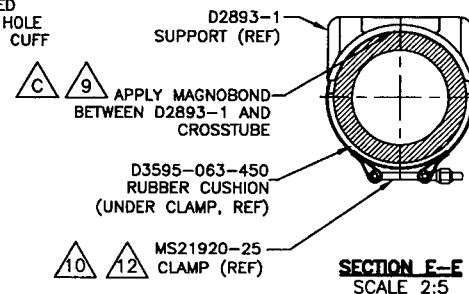
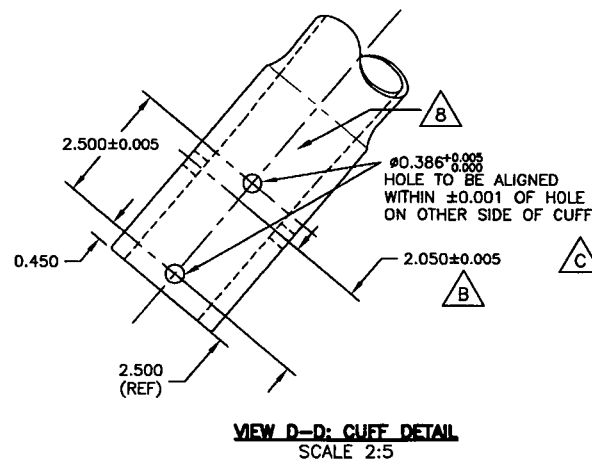
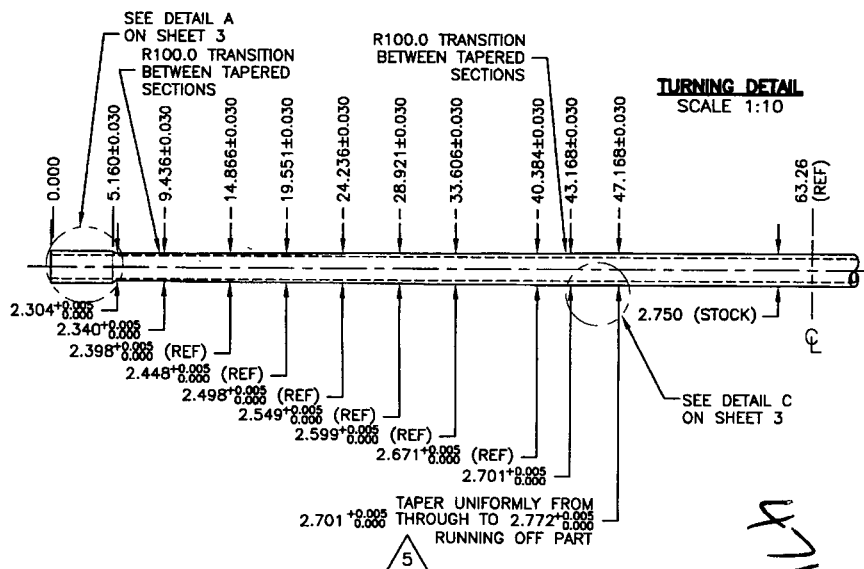
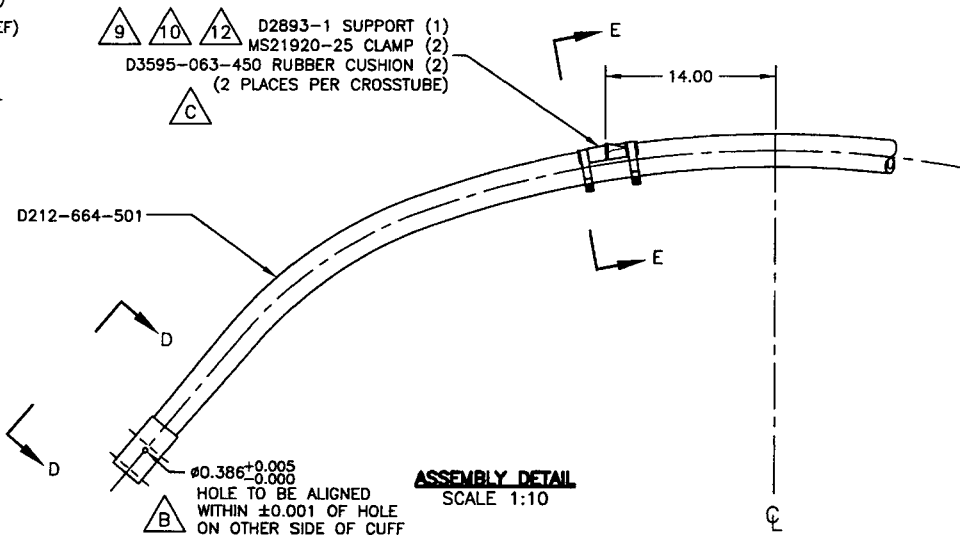
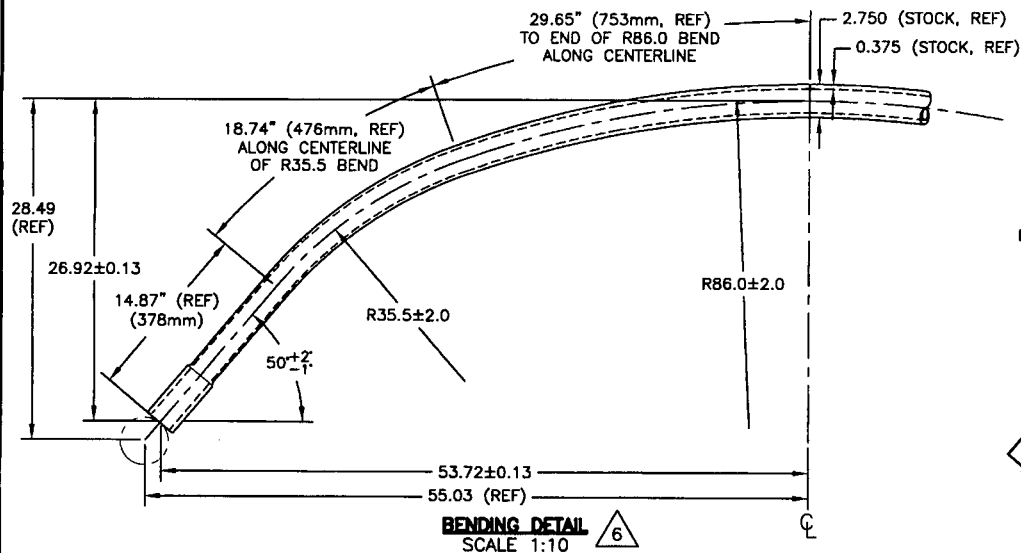
Qty	Part Number	Description
X	D212-664-141	CROSSTUBE ASSEMBLY (205/212/412 HIGH FWD)
1	D6005-128	CROSSTUBE
2	D2893-1	SUPPORT
4	D3595-063-450	RUBBER CUSHION
4	MS21920-25	CLAMP (OR MS21920-26)
A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

**GENERAL NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6005-128  
FINISHED LENGTH = 126.51±0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 3 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2893-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 10) INSTALL MS21920-25 CLAMPS (OR -26) WITH D3595-063-450 RUBBER CUSHIONS TO SECURE THE D2893-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMPS ARE OPPOSITE OF CROSSTUBE SUPPORT
- 11) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 12) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

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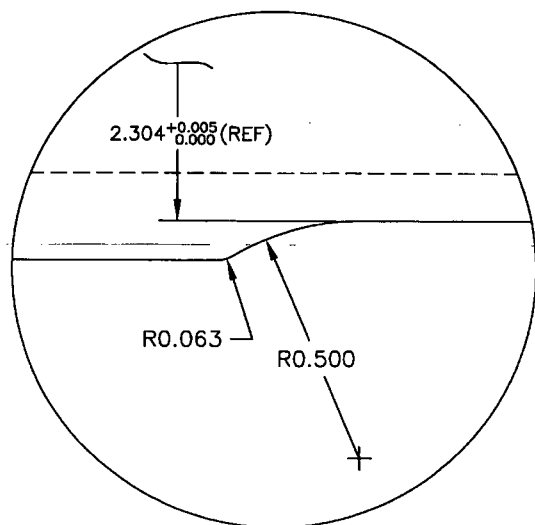
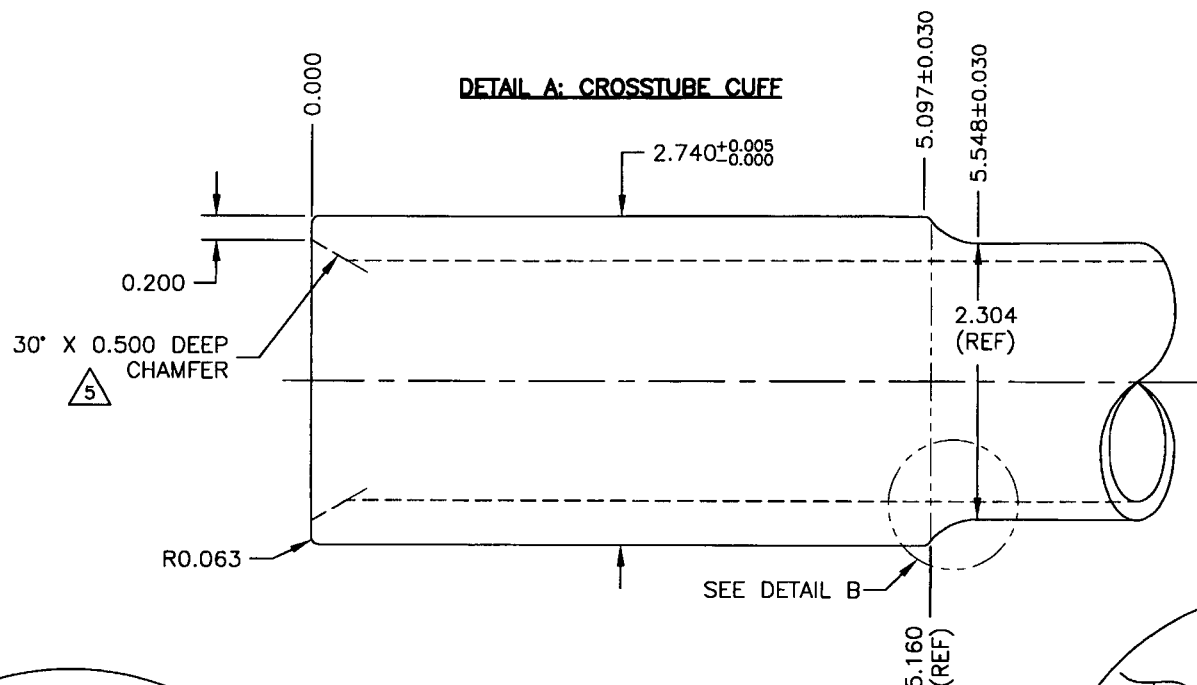


RELEASED

04.24

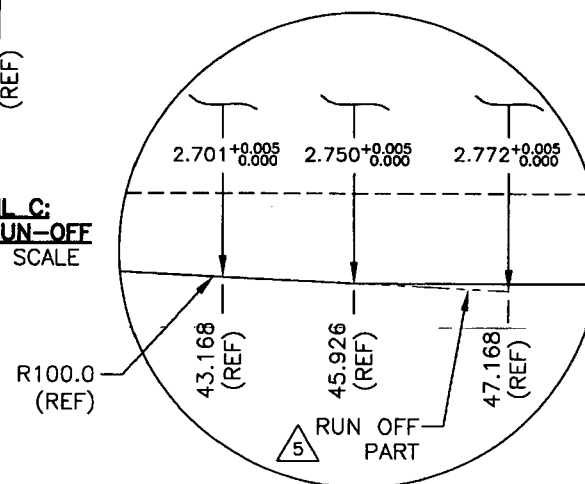
COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	<b>DART</b>	DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	GP	APPROVED	PH	DRAWING NO. D212-664-141	REV. C SHEET 2 OF 3
		DATE	07.03.08	TITLE		XTUBE ASS'Y (205/212/412 HI FWD)	SCALE 1:10

**RELEASED**  
87.04.24 (P)  
PER E.N. 883



47147

**DETAIL C: TAPER RUN-OFF**  
NOT TO SCALE



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DATE 07.03.08		TITLE XTUBE ASS'Y (205/212/412 HI FWD)		SCALE 1:1	



## LIQUID PENETRANT TEST REPORT

P- 15005

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE APR 16 09 TIME AM ☒ PM ☐  
ATTENTION LINDA LACELLE ACUREN JOB NO. 188-09-1375  
ADDRESS 1270 ABERDEEN PO/WO NO. 8579  
HAWKESBURY, ONT. WORK LOCATION HAWKESBURY ONT  
ACCEPTANCE STD. ASTM 1417 REV./DATE \_\_\_\_\_  
PROJECT \_\_\_\_\_  
ITEM(S) EXAMINED X TUBES + BRACKETS

JOB DESCRIPTION \_\_\_\_\_ PROCEDURE NO. LT-X2X REV./DATE 20APR07 TECHNIQUE NO. LT-XY2X REV./DATE 2007  
PART NO. \_\_\_\_\_ MATERIAL ALUM/SS. THICKNESS \_\_\_\_\_  
SCOPE FLPI ON 100% EXTERNAL SURFACE.

## TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED  
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 1081 ☒ OUTPUT > 1000  $\mu$ W/cm<sup>2</sup> ☐ AMBIENT < 2 fc  
PENETRANT ZL67 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE  
PENETRANT REMOVER H2O MINIMUM DRY TIME >10 MIN. OTHER \_\_\_\_\_  
DEVELOPER ZD9F MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N \_\_\_\_\_ CAL DUE DATE MAY 24 09  
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

## TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL  
SURFACE TEMPERATURE ☐ < - 4°C/ 20°F ☐ - 4°C/ 20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☒ > 52°C/125°F

RESULTS- ( ☐ METRIC ☐ IMPERIAL )

COMMENTS	ACCEPT	REJECT
JOB: 44683 PIN D36871-3 BRACKETS		
47147 D212664K01 212/205 HIGH FED X TUBE		
47150 " " " " " "		
46812 D407667105 407 FWD X TUBE		
46813 " " " " " "		
46814 D407667205 407 HIGH AFT X TUBE		
NO INDICATIONS OF DEFECTS ITEMS ACCEPTABLE TO CODE		

## Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

## Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

## SIGNATURES

CLIENT REPRESENTATIVE [Signature] DTR # E27432  
TECHNICIAN (SIGNATURE): [Signature] SIGNATURE \_\_\_\_\_  
NAME (PRINT): J. HEWITT REPORT REVIEWED BY: \_\_\_\_\_  
1<sup>ST</sup> TECHNICIAN 2<sup>ND</sup> TECHNICIAN  
CGSB LEVEL 2 SNT LEVEL 2 CGSB LEVEL \_\_\_\_\_ SNT LEVEL \_\_\_\_\_  
CGSB REG. NO. 6156 CGSB REG. NO. \_\_\_\_\_

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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